

Work Order ID 61007

August 4, 2010 8:55:22 AM



Page 1

Item ID: D4148-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stud Receiver, Lower

Start Date: 8/04/10 Start Qty: 10.00



Cust Item ID:

Required Date: 8/11/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

10-8-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4148

B

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

5.700" LONG

10/08/11

10

0

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA944 AND DWG

FOLIO REV: HA

DWG REV: B

DEBURR

10-8-12

10/08/14

10

0



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61007

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Page 2

Item ID: D4148-3

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Setup Start



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Item Name: Stud Receiver, Lower

Start Date: 8/04/10 Start Qty: 10.00



Cust Item ID:

Required Date: 8/11/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				10	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				10	0		
170 Packaging Packaging	Identify as per dwg & Stock Location <u>122</u> Memo	0.00 0.00							

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Page 3

Item ID: D4148-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stud Receiver, Lower

Start Date: 8/04/10 Start Qty: 10.00



Cust Item ID:

Required Date: 8/11/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/10 *[Signature]*

MF

10-8-10 *[Signature]*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

August 4, 2010 8:55:26 AM

Page 1

Work Order ID: 61007



Parent Item: D4148-3



Parent Item Name: Stud Receiver, Lower

Start Date: 8/04/10

Required Date: 8/11/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.500X03.000		Purchased	No			100	f	7.5947	0.48	5.052632			



303 Bar

Location

Loc Qty

Loc Code

MAT53

7.5947

112142

7.5947

5.052 only 10/6/11

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DART AEROSPACE LTD		Work Order: 61007
Description: STD RECEIVER LOWER		Part Number: D4148-3
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

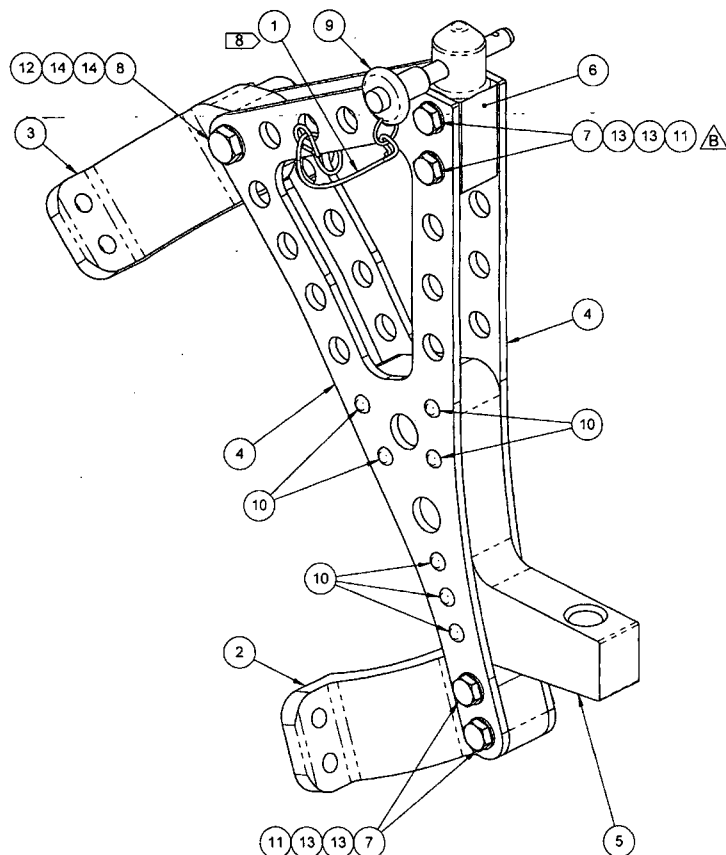
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.94	+/- .030	.940	/		Vernier	
.50	+/- .030	.500	/			
.129	+ .005 - .001	.129	/			
.65	+/- .030	.651	/			
.375	+/- .010	.379	/			
.750	+/- .010	.750	/			
1.10	+/- .010	1.099	/			
2.284	+/- .010	2.286	/			
2.38	+/- .030	2.38	/		RAD GAGE	
1.000	+/- .010	1.000	/		Vernier	
.340	+/- .010	.338	/			
2.526	+/- .010	2.528	/			
.368	+/- .010	.369	/			
3.97	+/- .030	3.970	/			
2.12	+/- .030	2.120	/			
.453	+ .010 - 0.0	.460	/			
.250	+ .006 - .001	.250	/			
.46 x .45	+/- .030	.060	/			
.80	+/- .030	.860	/			
.625	+/- .010	.627	/			
4.64	+/- .030	4.639	/			

Measured by: [Signature]	Audited by: [Signature]	Preliminary Approval:
Date: 10.8.12	Date: 10/08/14	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

8 7 6 5 4 3 2 1



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.47 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	4	AN3C12A	
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	7	MS20615-4M18	RIVET
11	4	MS21043-3	NUT
12	1	MS21043-4	NUT
13	8	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61007

PS 10-8-04

RELEASED
2010-07-16
mb

B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS Ø.129 (ZN C8-5) REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	9		
MFG. APPR.	9		
APPROVED	9		
DE APPR.	9		
DATE	10.07.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4148 REV. B SHEET 1 OF 5 FWD X-TUBE LUG ASSY SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR CONSULTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

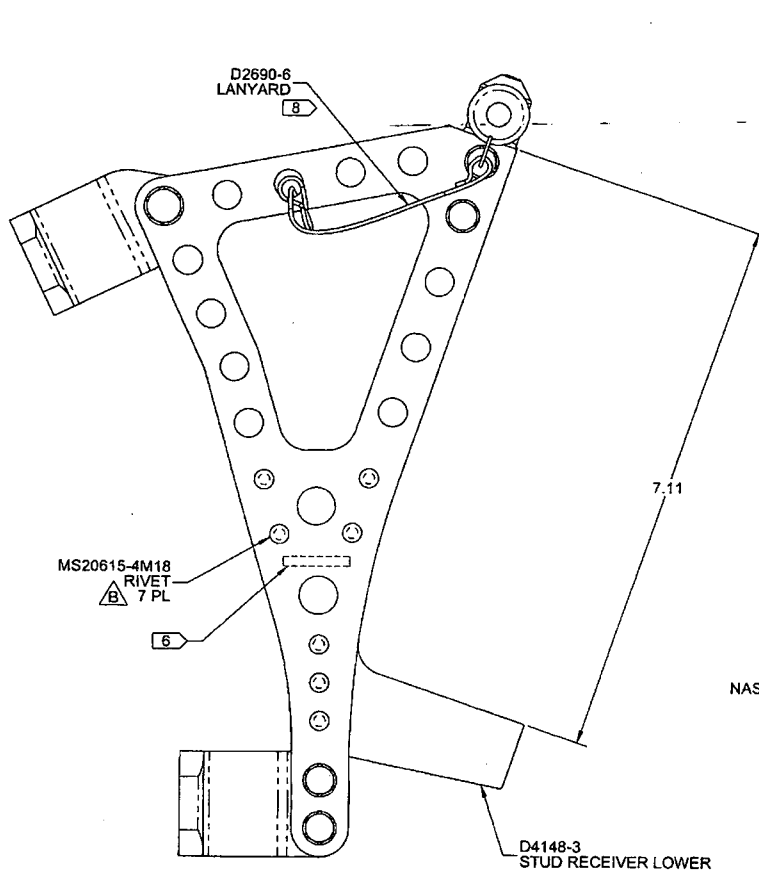
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

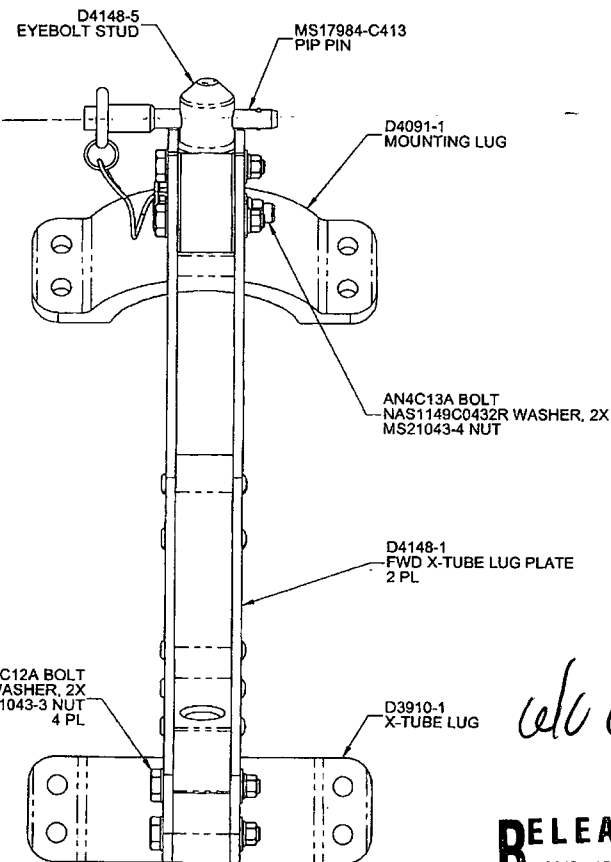
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY



W/C 61007

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2010-07-16
mp

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4148	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	10.07.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

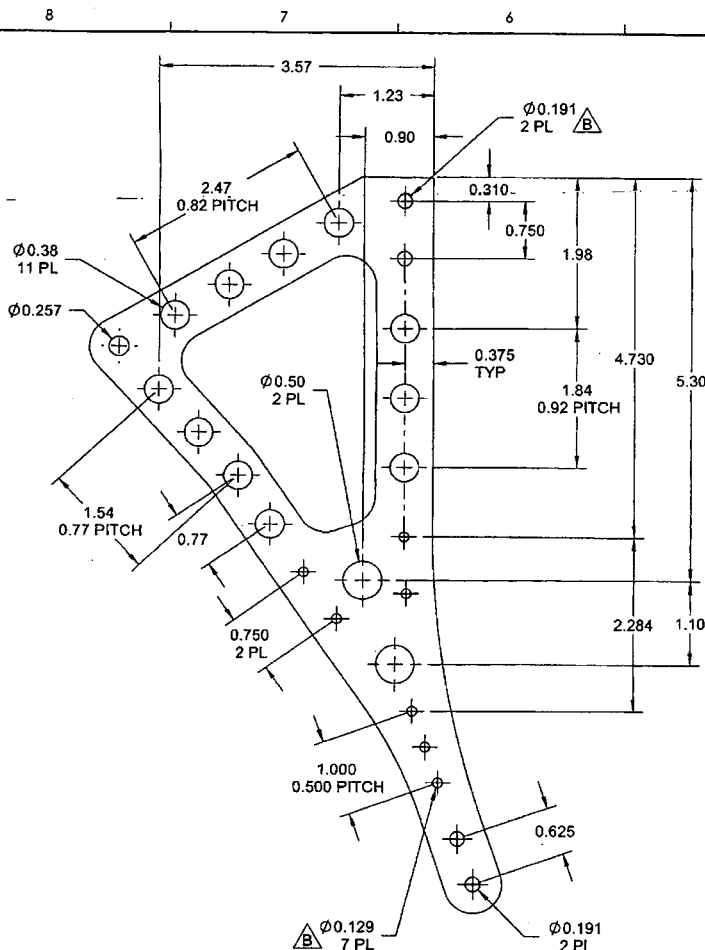
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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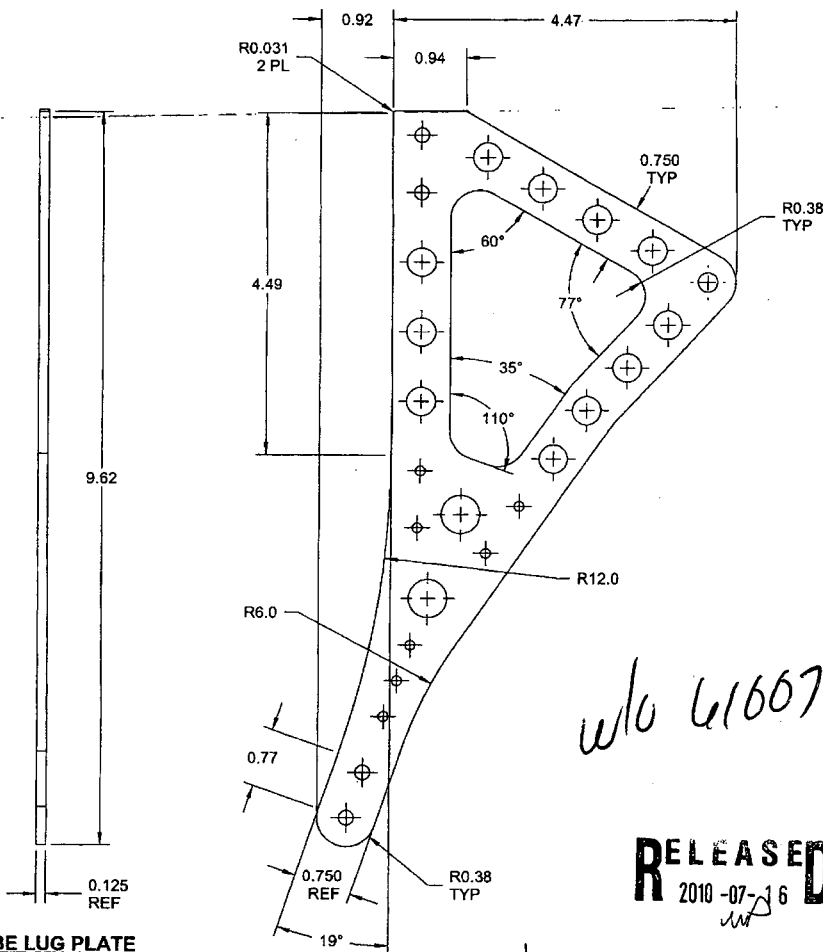
NOTE: Date & initial all entries



D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC MS304S11GA OR MS303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.48 lbs



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2010-07-16

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4148	REV. B
MFG. APPR.		SHEET 3 OF 5	
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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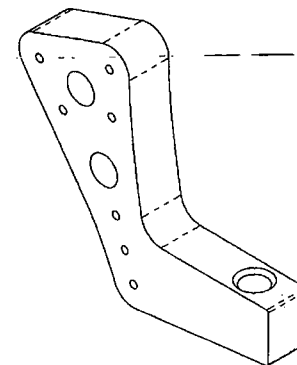
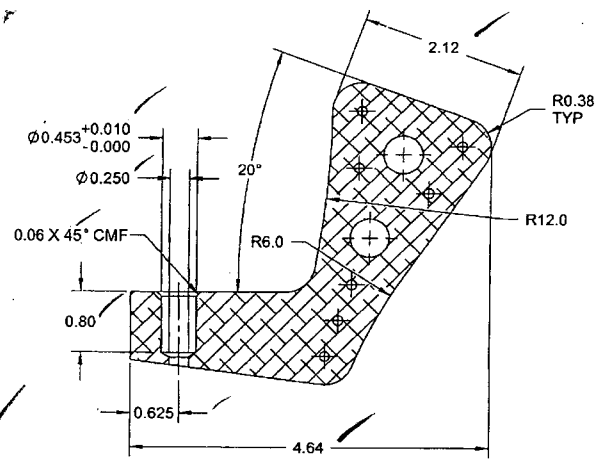
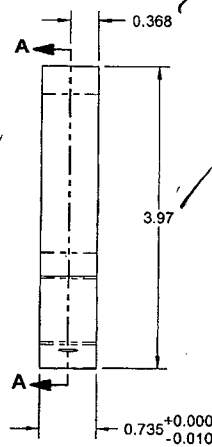
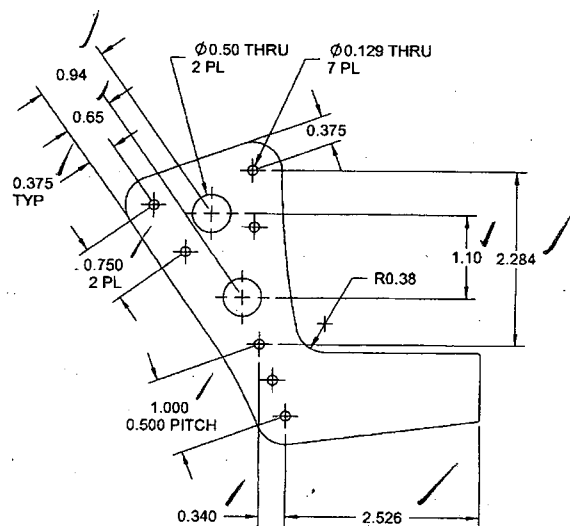
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



W6 61007

D4148-3 STUD RECEIVER LOWER

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.44 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4148	SHEET 4 OF 5
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8 7 6 5 4 3 2 1

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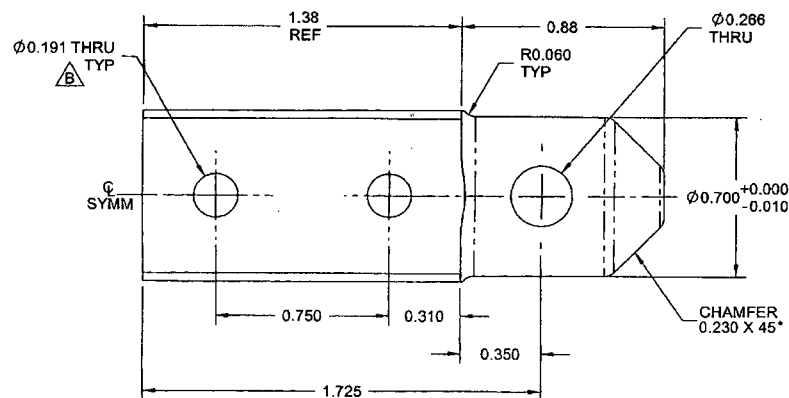
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

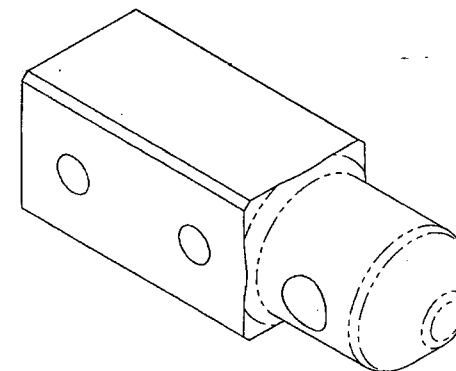
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4148-5 EYEBOLT STUD



w/b 61067
RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4148	SHEET 5 OF 5
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